

Date: Thursday, 9/20/2007 3:27:12 PM
User: Kim Johnston

Process Sheet

41

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : CONSOLE ASSEMBLY 407
Job Number : 34744	
Estimate Number : 11720	
P.O. Number : <i>N/A</i>	Part Number : D407547047
This Issue : 9/20/2007 S.O. No. : <i>N/A</i>	Drawing Number : D206-547 REV F
Prsht Rev. : NC	Project Number : N/A
First Issue : <i>N/A</i> Type : SMALL /MED FAB	Drawing Revision : F
Previous Run : <i>N/A</i>	Material : <i>N/A</i>
Written By : <i>[Signature]</i>	Due Date : 10/10/2007 Qty: <i>4</i> Um: Each
Checked & Approved By : <i>[Signature]</i> 07.09.20	
Comment : Est Rev: 06-01-05 Removed Packing Kit JLM	

Additional Product

Job Number: 

Seq. #:	Machine Or Operation:	Description :
1.0	D2024	Extrusion, Console
		
Comment: Qty.: 3.5910 Each(s)/Unit Total : 17.9550 Each(s) D2024 Extrusion Batch <i>M1</i>		
		<i>FF 07-10-23</i>
2.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
		
Comment: SMALL & MEDIUM FAB RESOURCE 1 1-Cut D2710-1, D2710-2, D2710-3, D2710-4 from D2024 Extrusion as per Dwg D2710 and templates DT 8264-1, DT 8264-2, DT8264-3, DT8264-4 2-Deburr		
		<i>FF 07-10-24</i>
3.0	QC6	DIMENSIONAL CHECK
		
Comment: DIMENSIONAL CHECK		
		<i>SP 07/10/24</i>
4.0	D26041	407 Hi Console Side LH
		
Comment: Qty.: 1.0000 Each(s)/Unit Total : 5.0000 Each(s) Pick: Qty Part Number Description Batch 1 D2604-1 Side LH <i>B22658</i>		
		<i>FF 07-10-24</i>
5.0	D26042	407 Hi Console Side RH
		
Comment: Qty.: 1.0000 Each(s)/Unit Total : 5.0000 Each(s) Pick: Qty Part Number Description Batch 1 D2604-2 Side RH <i>B22658</i>		
		<i>FF 07-10-24</i>

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 9/20/2007 3:27:12 PM
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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: CONSOLE ASSEMBLY 407

Job Number: 34744

Part Number: D407547047

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

D2606

Hi Console Bracket



Comment: Qty.: 1.0000 Each(s)/Unit Total : 5.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

1 D2606

Bracket B 33908

FF 07-10-24

(4)

7.0

D2608

407 Console Bracket



Comment: Qty.: 1.0000 Each(s)/Unit Total : 5.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

1 D2608

Bracket B 17357

FF 07-10-24

(4)

8.0

MS20470AD33

Rivet, Universal Head



Comment: Qty.: 6.0000 Each(s)/Unit Total : 30.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

6 MS20470AD3-3

Rivet M 1065

FF 07-10-24

(4)

9.0

MS20470AD34

Rivet, Universal Head



Comment: Qty.: 20.0000 Each(s)/Unit Total : 100.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

20 MS20470AD3-4

Rivet M 15541

FF 07-10-24

(4)

10.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

1-Grind weld relief chamfer as per Dwg D206-547

2-Rivet extrusion to sides as per Dwg D206-547 using Rivet MS20470AD3-4

FF 07-10-24

(4)

FF 07-10-24

4

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 9/20/2007 3:27:13 PM
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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: CONSOLE ASSEMBLY 407

Job Number: 34744

Part Number: D407547047

Job Number:



Seq. #:

Machine Or Operation:

Description :

11.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

07/10/24

4RH
4LH

12.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

1-Tack weld as per Dwg D206-547

A/R AL ROD Batch: M10756

10/10/25
2-Grind weld

FF 07-10-25

PD 07-10-25

4RH
4LH

13.0

DO NOT USE

QC9

WELD INSPECTION



Comment: WELD INSPECTION

07/10/25

07/10/25 (4)

14.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

10/10/25
1-Rivet sides and brackets per Dwg D206-547 using Rivet MS20470AD3-3

FF 07-10-25

(4)

15.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

07/10/25 (4)

16.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat Black Sandtex (Ref: 4.3.5.7) as per QSI 005 4.3

M103316

07-10-26 (x4)

17.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

07/10/25 (4)

18.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:

07/10/24 (4)

PPI 407-549-017

B34682

07.10.29

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: D Date: 07/11/07

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 9/20/2007 3:27:13 PM
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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: CONSOLE ASSEMBLY 407

Job Number: 34744

Part Number: D407547047

Job Number:



Seq. #:

Machine Or Operation:

Description :

19.0

QC21

FINAL INSPECTION/W/O RELEASE



(4)

Comment: FINAL INSPECTION/W/O RELEASE

20/10/07

Job Completion



U 9/10/29

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

4. WEIGHT AND BALANCE

Installation	Weight	LATERAL		LONGITUDINAL	
		Arm	Moment	Arm	Moment
D206-549-011	2 lbs 0.907 kg	0 in 0 m	0 lbs-in 0 kg-m	48.0 in 1.22 m	96.00 lbs-in 1.11 kg-m
D206-549-013	2 lbs 0.907 kg	0 in 0 m	0 lbs-in 0 kg-m	48.0 in 1.22 m	96.00 lbs-in 1.11 kg-m
D407-549-015	2 lbs 0.907 kg	0 in 0 m	0 lbs-in 0 kg-m	48.0 in 1.22 m	96.00 lbs-in 1.11 kg-m
D407-549-017	2 lbs 0.907 kg	0 in 0 m	0 lbs-in 0 kg-m	48.0 in 1.22 m	96.00 lbs-in 1.11 kg-m

5. PARTS LIST

-011	-013	-015	-017	Part Number	Description
X				D206-549-011	LOW SLOPE CONSOLE INSTALLATION, 206
	X			D206-549-013	HIGH SLOPE CONSOLE INSTALLATION, 206
		X		D407-549-015	LOW SLOPE CONSOLE INSTALLATION, 407
			X	D407-549-017	HIGH SLOPE CONSOLE INSTALLATION, 407
REF	REF	REF	REF	D1038-58	FASTENER RAIL
REF	REF	REF	REF	D1038-58B	FASTENER RAIL, BLACK
1	1	1	1	D2163	CAP ANGLE
1				D206-547-041	206 LOW SLOPE CONSOLE ASSEMBLY
	1			D206-547-043	206 HIGH SLOPE CONSOLE ASSEMBLY
		1		D407-547-045	407 LOW SLOPE CONSOLE ASSEMBLY
			1	D407-547-047	407 HIGH SLOPE CONSOLE ASSEMBLY
2	2	2	2	D206-547-11	ANGLE
28	28	28	28	MS20470AD4-5	RIVET
14	14	16	16	AN960JD10L	WASHER
14	14	16	16	MS27039-1-08	SCREW

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 NO. 34744



DESIGN BW	DRAWN BY RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED UP	APPROVED KE	DRAWING NO. D206-547	REV. F SHEET 1 OF 5
DATE 99.02.11		TITLE CONSOLE ASSEMBLY	SCALE NTS
-	82.11.23	NEW ISSUE	
A	83.01.18	REDRAWN, ADD NOTE 4	
B	84.10.23	D206-547 WAS 01.B.81.017	
C	89.03.30	REDRAWN	
D	90.12.06	COMPANY NAME CHANGE MS20470 WAS MS20426 DIM 1.312 WAS 1.0, 13.160 WAS 12.85	
E	97.10.22	REDRAWN, ADD -043,-045,-047	
F	99.02.11	ADD MS20470AD3-3 RIVET (NC 143) UPDATED WELD DETAIL	

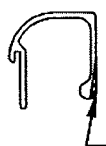
RELEASED
99.03.05 RE

-041	-043	-045	-047	PART NUMBER	DESCRIPTION
X				D206-547-041	CONSOLE ASSEMBLY
	X			D206-547-043	CONSOLE ASSEMBLY
		X		D407-547-045	CONSOLE ASSEMBLY
			X	D407-547-047	CONSOLE ASSEMBLY
1				D2601-1	CONSOLE SIDE
1				D2601-2	CONSOLE SIDE
	1			D2602-1	CONSOLE SIDE
	1			D2602-2	CONSOLE SIDE
		1		D2603-1	CONSOLE SIDE
		1		D2603-2	CONSOLE SIDE
			1	D2604-1	CONSOLE SIDE
			1	D2604-2	CONSOLE SIDE
1		1		D2605	CONSOLE BRACKET
	1		1	D2606	CONSOLE BRACKET
1	1			D2607	CONSOLE BRACKET
		1	1	D2608	CONSOLE BRACKET
1		1		D2709-1	CONSOLE SIDE RAIL
1		1		D2709-2	CONSOLE SIDE RAIL
1		1		D2709-3	CONSOLE SIDE RAIL
1		1		D2709-4	CONSOLE SIDE RAIL
	1		1	D2710-1	CONSOLE SIDE RAIL
	1		1	D2710-2	CONSOLE SIDE RAIL
	1		1	D2710-3	CONSOLE SIDE RAIL
	1		1	D2710-4	CONSOLE SIDE RAIL
10	8	8	6	MS20470AD3-3	RIVET
18	20	18	20	MS20470AD3-4	RIVET

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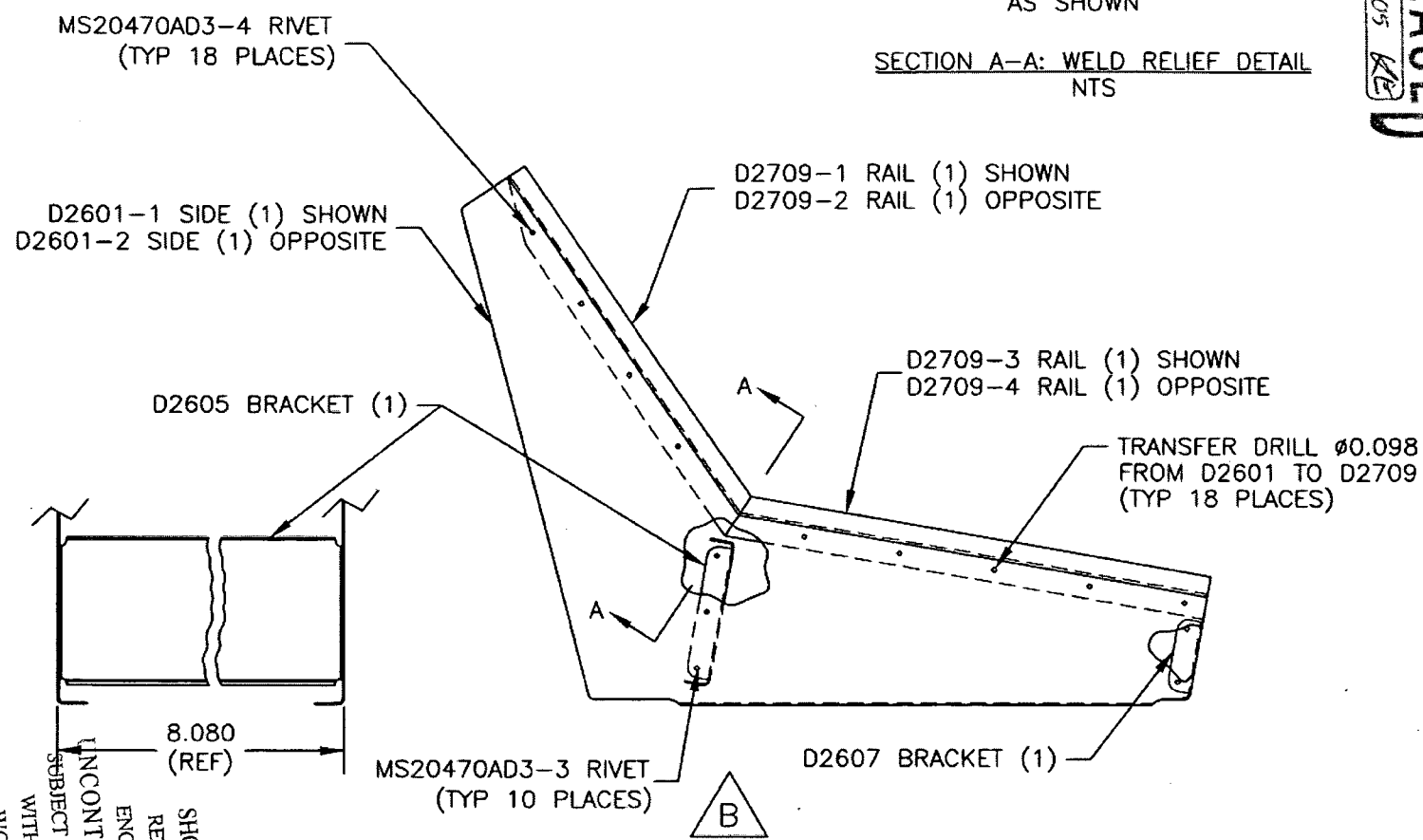


RELEASED
49.0305 KE



GRIND RELIEF
CHAMFER FOR WELD
0.040-0.050 x 45°
AS SHOWN

SECTION A-A: WELD RELIEF DETAIL
NTS



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DATE	99.02.11	DRAWING NO.	D206-547	REV. F
		TITLE	CONSOLE ASSEMBLY	SHEET 2 OF 5
				SCALE 1:4

206-547-041 (206 LOW SLOPE CONSOLE)

FINISH: POWDER COAT ASSEMBLY MATTE BLACK (4.3.5.4) PER DART QSI 005 4.3
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

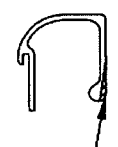
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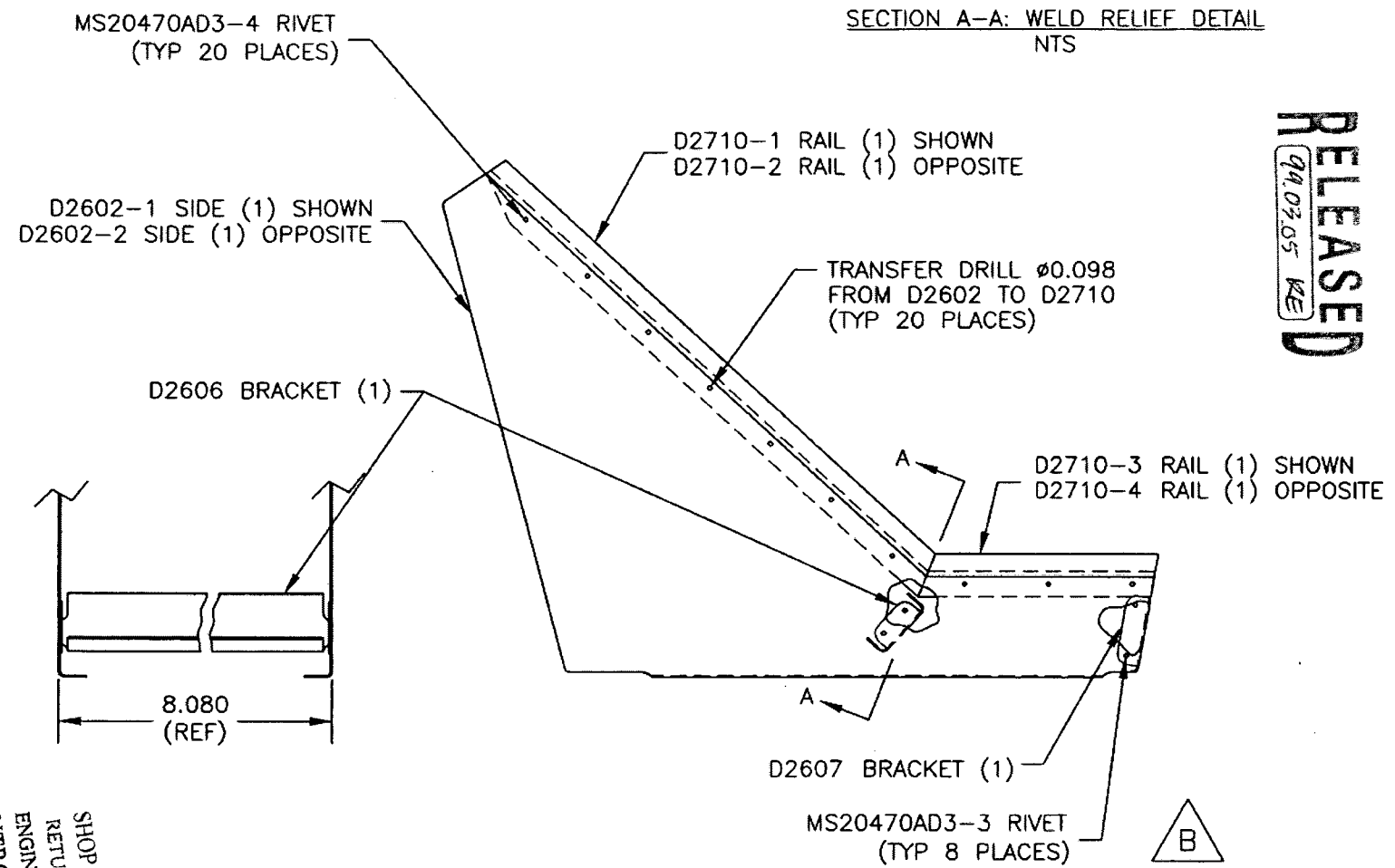
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DATE 99.02.11	TITLE CONSOLE ASSEMBLY	SCALE 1:4	



GRIND RELIEF
CHAMFER FOR WELD
0.040-0.050 x 45°
AS SHOWN

SECTION A-A: WELD RELIEF DETAIL
NTS



D206-547-043 (206 HIGH SLOPE CONSOLE)

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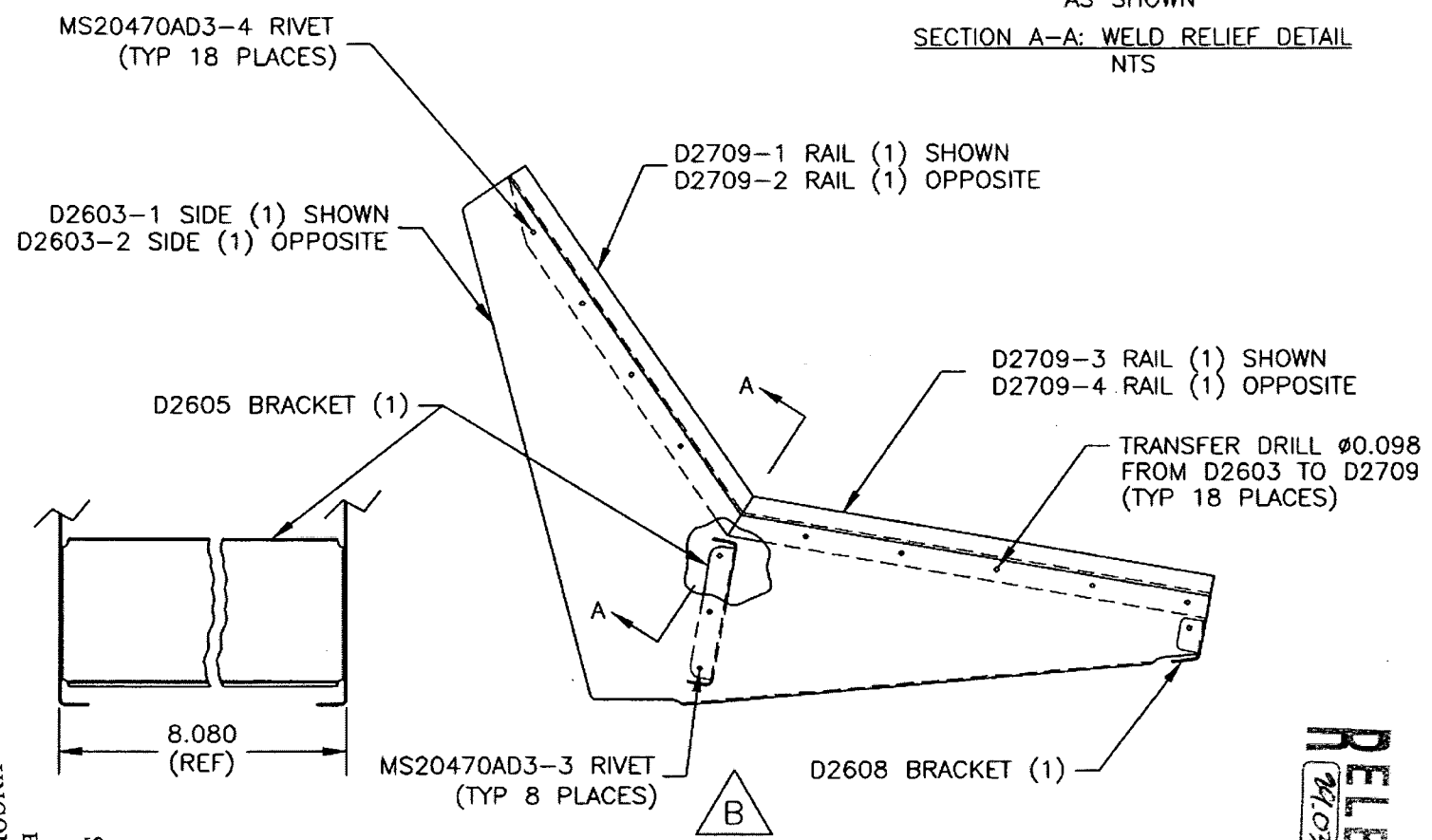
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CHAMFER FOR WELD
0.040-0.050 x 45°
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SECTION A-A: WELD RELIEF DETAIL
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CHECKED JP	APPROVED AE	DRAWING NO. D206-547	SHEET 4 OF 5
DATE 99.02.11	TITLE CONSOLE ASSEMBLY	SCALE 1:4	

407-547-045 (407 LOW SLOPE CONSOLE)

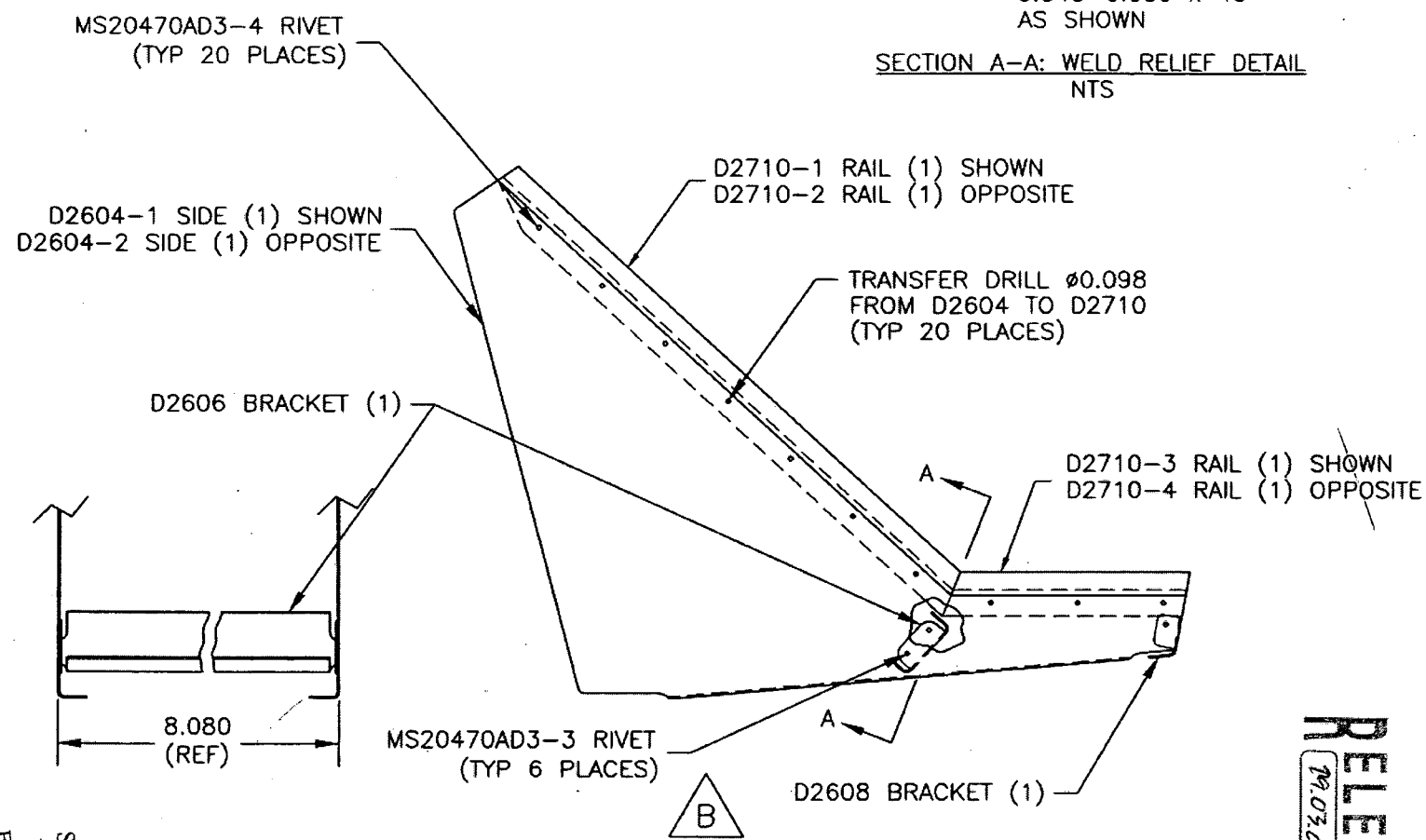
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SECTION A-A: WELD RELIEF DETAIL
NTS



D407-547-047 (407 HIGH SLOPE CONSOLE)

FINISH: POWDER COAT ASSEMBLY MATTE BLACK (4.3.5.4) PER DART QSI 005 4.3
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RELEASED
19.03.05 KE

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DATE	99.02.11	DRAWING NO.	D206-547	REV. F
		TITLE	CONSOLE ASSEMBLY	SHEET 5 OF 5
				SCALE 1:4

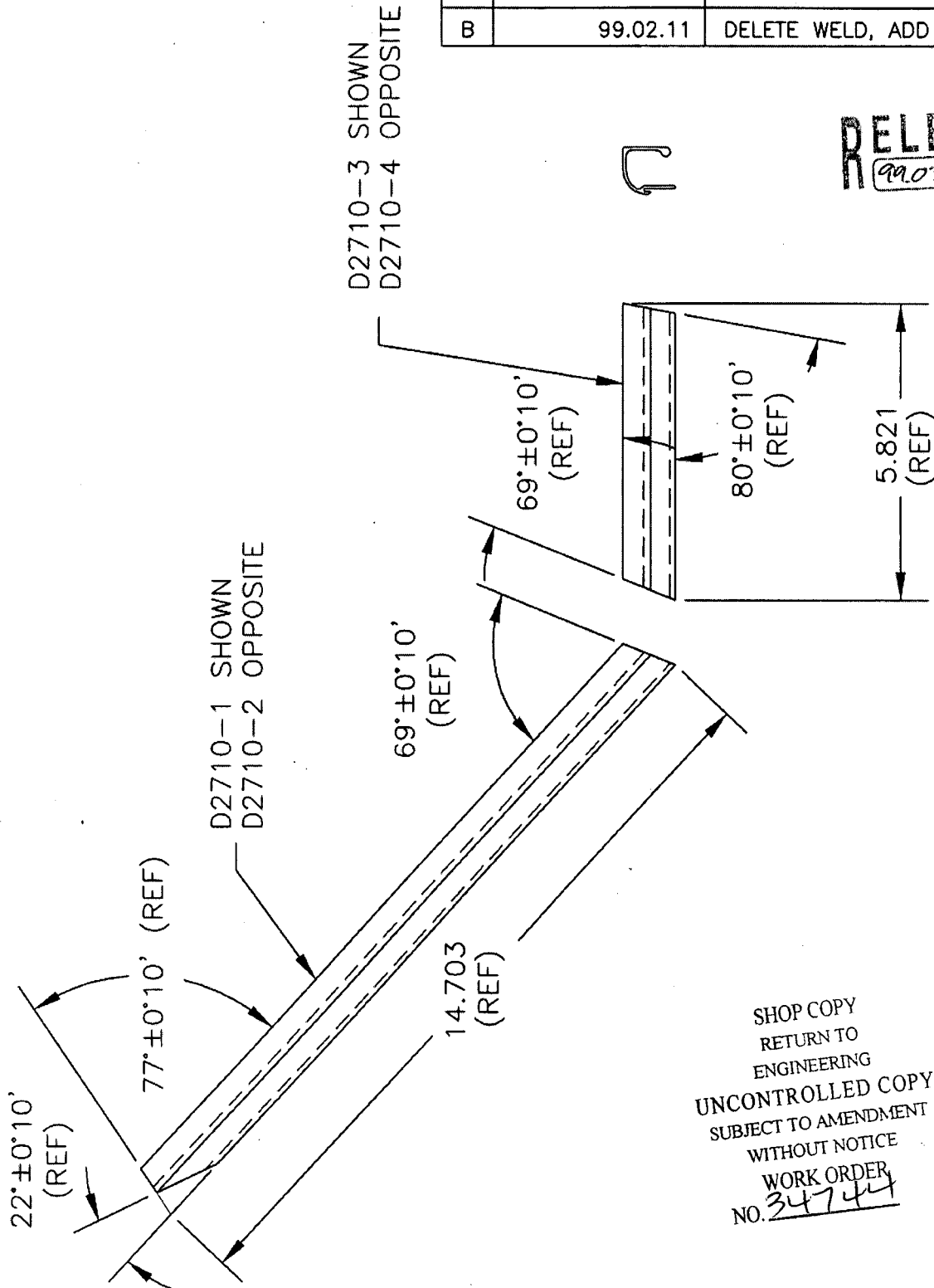
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DESIGN BW	DRAWN BY RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED UP	APPROVED KE	DRAWING NO. D2710	REV. B SHEET 1 OF 1
DATE 99.02.11	TITLE CONSOLE SIDE RAIL		SCALE 1:3
A	97.10.25	NEW ISSUE	
B	99.02.11	DELETE WELD, ADD TEMPL. (TSR A1020)	

RELEASED
99.07.05 KE



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MAKE PER TEMPLATE # DT8264
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